

Date: Wednesday, 17/09/2008 3:51:16 PM
 User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACER
Job Number : 42077	
Estimate Number : 13580	
P.O. Number :	Part Number : D38161
This Issue : 17/09/2008 S.O. No. :	Drawing Number : D38161 PREL
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : PREL
Previous Run :	Material :
Written By : <u>JLM 08-09-17</u>	Due Date : 24/09/2008 Qty: 4 Um: Each
Checked & Approved By :	
Comment : Est Rev: A New Issue 08-09-17 JLM Verified By: EC	

Additional Product

FOR ENGINEERING USE ONLY

~~PRELIMINARY ISSUE~~

Positive Recall

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6R0375 6061-T6 Round Bar .375"



JLM 08-09-22



Comment: Qty.: 0.1050 f(s)/Unit Total: 0.4200 f(s) M 6061T6 0375 W058

6061-T6 Round Bar .375"

M 109 314

Batch: _____

2.0 DOOSAN LATHE DOOSAN LATHE



Comment: Doosan Lathe

1- Turn as per Folio FA784 Rev: N/A & Dwg D3816 Rev: A

2-Deburr per dwg D3816

SA 08/09/21

(10)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 08/09/21

(10)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SA 08/09/21

(10)

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JLM

08-10-02

(10)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 42077

Part Number: D38161

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



10X

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-h

08/10/02

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

Harvey

AS

8/10/03

(XO)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



POSITIVE RECALL

EFFECTIVE *08/10/03* AUTH *u*

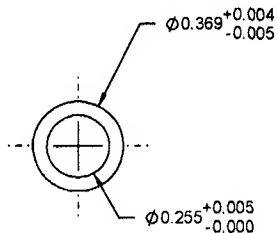
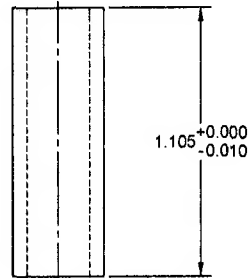
RELEASED _____ DATE _____

N/A

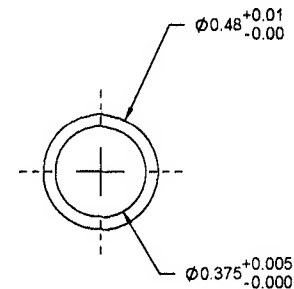
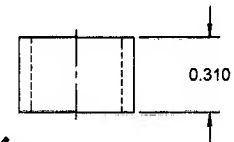
08/10/03

00252A

PRELIMINARY ISSUE



D3816-1 SPACER



D3816-3 SPACER

NOTES:

- 1) MATERIAL: ~~5052H32~~ 5052H32 ROUND BAR PER QQ-A-225/7 (REF DART SPEC M5052H32R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3816-1/-3 USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3816-1 0.01 lbs
D3816-3 0.01 lbs

6061-T6 *Ad.*

A	NEW ISSUE		BY	08.09.11
REV.	DESCRIPTION		DATE	
DESIGN				
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	08.09.11			
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